

Work Order ID 147509

Thursday, June 09, 2016 8:45:32 AM

147509

Page 1

Item ID: D3205-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Pedal Bracket

Start Date: 5/26/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 6/8/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Run Start

NR1

Stop

NR2

Approvals: Process Plan: MCS Date: JUN 10 2016

Tooling:

Date:

QC: Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3205

Rev C

100

0.00

100

BAND SAW

Bandsaw

Memo

0.07

Jeaspa Bandsaw

Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)

DAS
14
9-09

16/06/21

110

0.30

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.57

HAAS CNC vertical machine #1

Machine D3205-1 as per Folio FA346 and Dwg D3205Identify as D3205-1

Deburr and Tumble

DAS
14
9-09

16/06/22

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.01

Quality Control

16/6-23

(PTC)

DQA:

Date: 16.08.09

QA Closed: ~~REPLY~~

Date: 16/07/08

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>147509</u> Part No. <u>D3205-1</u> NCR No. <u>16-5887</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Date: <u>16-6-23</u>		Step #: <u>110</u>		QTY Effective: <u>1</u>		MRB (QSI042) Approval																																																																	
Description Work Order Deviation				Disposition		DAS 9 2-89 <u>16-06-23</u>																																																																	
<u>1 part dimension - 250 ± .010 to -237</u> <u>in one area only</u>				<u>Acceptable</u>		Completed By <u>SL</u> <u>16-6-23</u>																																																																	
						Lead hand / Supervisor Approval Verification DAS 14 9-89 <u>16/06/25</u>																																																																	
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OTHER :																																																																							

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147509

Page 2

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 5/26/2016 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 6/8/2016 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

121

-Mill Conv

Memo

0.17

Conventional Milling Machine

COUNTER SINK AS PER DWG

camp
D.4

32

9-85

16-06-24

0.00

122

QC

Memo

0.01

Quality Control

2

3

9

16-UG-24

0.00

130

OC

Memo

0.02

Quality Control

DA

4.

0.8

2016-6-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Work Order ID 147509

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147509

Page 3

Item ID: D3205-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pedal Bracket
 Start Date: 5/26/2016 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 6/8/2016 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140	HandFinish	0.03				5	0		Sh 16/06/2016
Hand Finishing	Memo								
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150	Powdercoat	0.02				5	0	16.07.5	238
Powder Coating	Memo								
	Note: Cover the thread hole for D3205-1 before powder coat.START TIME: 7:30 FINISH TIME: 8:20 OVEN TEMPERATURE: 325°								
160	QC3- Inspect Part Finish	0.00							
160	QC	0.01				5			38 9-80 JUL 11 5 2016
Quality Control	Memo								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 147509

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147509

Page 4

Item ID: D3205-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pedal Bracket
 Start Date: 5/26/2016 Start Qty: 5.00 *5* Cust Item ID:
 Required Date: 6/8/2016 Req'd Qty: 5.00 *5* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.01				5			DAS 6 9-89
Packaging	LOCATION : GA								
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.08							16/7/6 DJ
Quality Control									

DAS
21
9-89 JUL 06 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
		OTHER :							

Picklist Print

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Page 1

Work Order ID: 147509

147509

Parent Item: D3205-1

D3205-1

Parent Item Name: Pedal Bracket

Start Date: 5/26/2016

Required Date: 6/8/2016

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP A04.06.09New issueKJ/RF

IPP Rev:B 08-12-16 attach DEO DD verified by:EC

IPP

REV:C AS PER REV B 12-03-23 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B2.500X03.2 5		Purchased		No		100	f	5.3420	0.3646	1.918947			

M7075T73B2 500X03 25

7075-T73 Bar 2.50 x 3.25

Location

Loc Qty

Loc Code

MAT

5.342

m131479

2.942

→ m134336

2.4

1.92

my
16/06/21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : ☐			
Misidentified ☐	☐	Past Due ☐	☐				

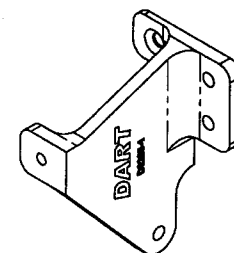
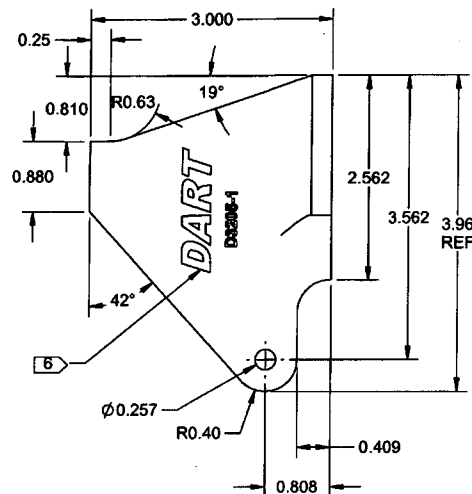
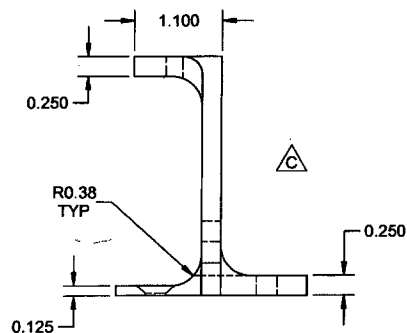
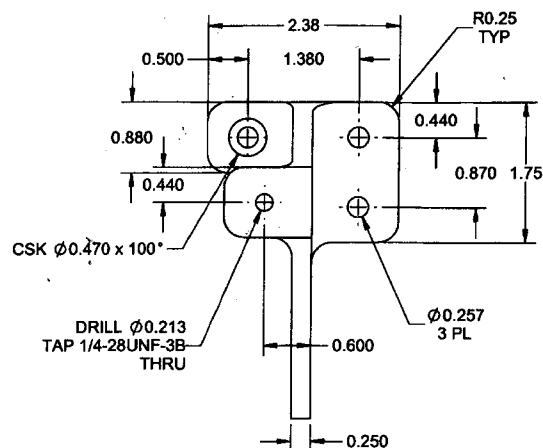
DART AEROSPACE LTD		Work Order: 147509
Description: Pedal Bracket		Part Number: D3205-1
Inspection Dwg: D3205	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.110	✓		VERN	SL-10
0.250	+/-0.010	0.250	✓			
R0.38	+/-0.030	R 0.375	✓			
0.125	+/-0.010	0.127	✓			
0.250	+/-0.010	0.251	✓			
2.380	+/-0.010	2.384	✓			
1.380	+/-0.010	1.380	✓			
0.500	+/-0.010	0.500	✓			
0.880	+/-0.010	0.880	✓			
Ø0.470 x 100°	+0.006/-0.001	0.476	✓		Caliper	JCL-08
0.440	+/-0.010	0.440	✓		VERN	SL-10
0.600	+/-0.010	0.600	✓			
1/4-28UNF-313	N/A		✓			
0.250	+/-0.010	0.255	✓			
Ø0.257	+0.006/-0.001	0.258	✓			
1.750	+/-0.010	1.750	✓			
0.870	+/-0.010	0.870	✓			
0.440	+/-0.010	0.442	✓			
R0.25	+/-0.030	0.250	✓			
3.000	+/-0.010	2.999	✓			
3.96	+/-0.030	3.960	✓			
0.409	+/-0.010	0.409	✓		HG	
0.808	+/-0.010	0.808	✓			
2.5623.562	+/-0.010	3.563	✓			

Measured by: SL/JCL	Audited by: 45 9-89	Preliminary Approval:
Date: 16-6-23	Date: 2016-6-27	Date:

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	12.05.14	Dimensions updated per Dwg Rev B	KJ	
C	13.02.27	Dwg Rev updated	KJ	



D3205-1 PEDAL BRACKET

NOTES:

- 1) MATERIAL: 7075-T73 ALUMINUM BAR
PER QQ-A-200/11 OR QQ-A-250/12
REF DART SPEC M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDING (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3
- 7) WEIGHT: 0.28 lbs

C	REMOVED GRAIN DIRECTION ON -1 (ZN B5-1) SEE PREVIOUS REV. FOR DETAILS. REF. PART 12-212	SFM	12.12.24
B	CONVERT DRAWING TO STANDARD FORMAT; 3.96 WAS 3.99 (ZN C2-1); 18" WAS 18" (D3-1); 42" WAS 41" (ZN C4-1); CHANGE DIMENSIONS TO 2 DEC. PL (ZN D5-1, D6-1, C4-2, D5-2, C7-2); ADD CHAMFER (ZN D3-2); REMOVE ENGRAVING ON D3205-3	RF	12.02.24
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	SFM		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.12.24		
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